

Work Order ID 113429

Thursday, February 13, 2014 3:22:05 PM

113429

Page 1

Item ID: PB67-43001-29

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade Positioner Weldment

Start Date: 2/13/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MF

Date: 14-2-13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-29

C

100

Weld per dwg A/R Aluminum rod Batch: H125051 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING****

1- ASSEMBLE AND WELD AS PER DWG

⑥ 14-03-19 PD

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

6x 14-03-21 DAS 43 9-89

100
3
100

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Item ID: PB67-43001-29 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade Positioner Weldment
 Start Date: 2/13/2014 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 2/28/2014 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	DAS 27 9.89	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		18/3/21			6			2-13-14
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 M 111077 Memo START TIME: 3:50 OVEN TEMPERATURE: 320° FINISH TIME: 4:20	0.00 0.00					6	14-3-26		DAS 34 9.89
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		Shw 14/3/27			6			

W. J. C. G. H. P.
1871 1872 1873 1874

1
2

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Page 3

Item ID: PB67-43001-29 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Blade Positioner Weldment
 Start Date: 2/13/2014 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 2/28/2014 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo <i>MOZZ 2</i>	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
32
9-89 *17/3/27* *(6)*

MLJ 14-03-27
MLJ 14-03-27

Picklist Print

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Page 1

Work Order ID: 113429

113429

Parent Item: PB67-43001-29

PR67-43001-29

Parent Item Name: Blade Positioner Weldment

Start Date: 2/13/2014

Required Date: 2/28/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313		Manufactured	No			100	Each	8.0000	1	6			
PR67-43001-313													
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				8					
				(54672)				8		6			
PB67-43001-319		Manufactured	No			100	Each	3.0000	2	12			
PR67-43001-319													
Gusset													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				3		B113945 → 12			
				99953				3					
PB67-43001-337		Manufactured	No			100	Each	1.0000	2	12			
PR67-43001-337													
Stop Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				1		B113946 → 11			
				(99952)				1					

**

(6) 14-03-17 PD

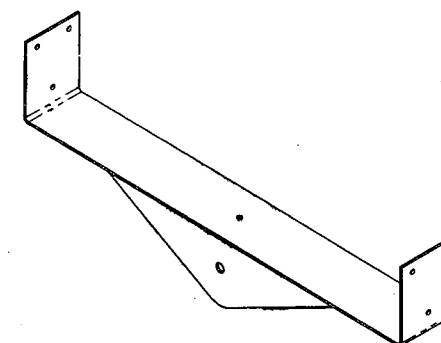
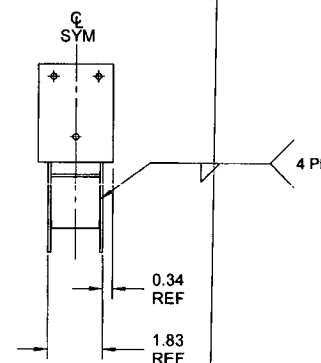
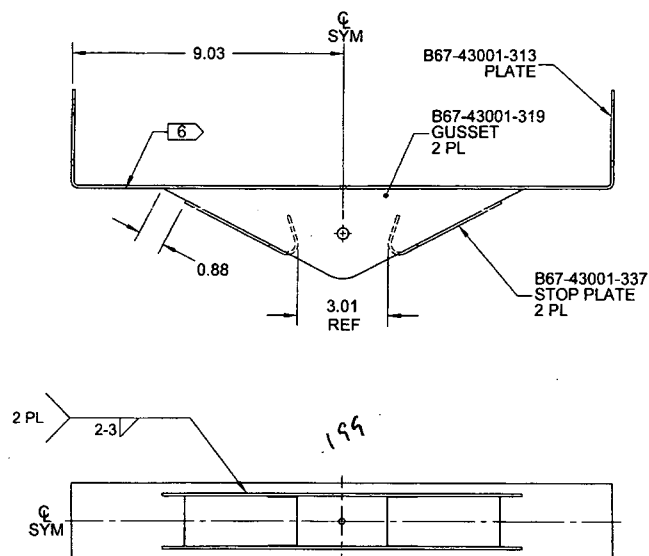
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(12) 14-03-17 PD

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(12) 14-03-17 PD

ITEM	QTY -29	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.01 lbs
- 8) WELDING: PER QSI 004

RELEASED
2009-09-24

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD	
DRAWN	JDS			HAWKESBURY, ONTARIO, CANADA	
CHECKED	JDS			DRAWING NO. B67-43001-29	
MFG. APPR.	JDS			REV. C	
APPROVED	JDS			TITLE	
DE APPR.	N/A			BLADE POSITIONER WELDMENT	
DATE	09.06.24			SCALE	
NTS					

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		